

PRODUCT BULLETIN
GYPSUM PRODUCTS

5/8" SOFFIT BOARD

BULLETIN NO: B-44
DATE: 11/17/72
PAGE: 1 of 3

APPROVALS:

TYPE X
ASTM C-630

CANCELS: NEW
DATE:

423K AK P4F

PRODUCING PLANTS:

Seattle Only

CORE FORMULA: (lbs/MSF)

Board Stucco	(S-1, S-2)	1650-1950
Paper Fiber	(B-G-1)	0-15
Vermiculite Ore	(RM B 28)	22-25
Glass Fiber	(B-G-1)	3.8-4.2
Starch	(RM B11A)	9-12.5

Core Foaming Agent:

ALS or AAS	(B-G-1)	0.2-1.7
Lignin	(B-G-1)	5.5-6.5
End Trim	(B-G-1)	0-35
Potassium Sulfate (in solution)	(B-G-1)	6.5-7.5
Retarder	(B-G-1)	0-0.8
Hydrated Lime	(RM P3)	0-0.5
Asphalt Wax Emulsion (RM B2A) (gal/MSF)		20-22

NOTE: Rotate inventory of asphalt-wax emulsion. Do not use emulsion over 30 days old without pretesting. Potassium sulfate must be fed in a water solution.

Paper Liners: Exterior board paper, Grade #7011, except that strength requirement of 45 lbs minimum cross machine tensile strength is satisfactory.

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OPERATING SPECIFICATIONS: (Refer to Process Bulletin B-G-2 for General Specifications)

1. Slurry slump, inches 4-1/2 - 7
2. Slurry Setting Time, minutes 2 - 4-3/4
3. Wet Slurry Weight, lbs/cu.ft. 75 - 85
4. Wet Compressive Strength, psi 200-400
5. Moisture Content (take off prong type) 15 - 20%
6. Printing: Use non-bleeding ink for all printing on Soffit Board. Face printing shall read Kaiser Gypsum Soffit Board - Type X and shall be spaced 7 inches in from one edge.

PRODUCT SPECIFICATIONS: (Refer to Product Bulletin B-G-4 for General Specifications and to Test Method Bulletin)

Wet Weight (lbs/MSF)	3300- 3600
Dry Weight (lbs/MSF)	2200 - 2400
Evaporation Loss (lbs/MSF)	1225 - 1325
Thickness - Average (inch)	.605 - .640
Thickness - Individual Reading (inch)	± .010 from average
Edges:	Round Tapered Edge
Taper Depth (inch)	0.010 to 0.015
Taper Width (inch)	1-3/4 - 2
Edge Hardness at Take-off (lbs)	10 minimum
End Peel after Sawing (inch) (both leading and trailing ends)	1/8 maximum
Flexural Strength, minimum	
Across grain (lbs)	250 minimum
Parallel (lbs)	100 minimum

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OK JWP
PRODUCT SPECIFICATIONS: (Refer to Product Bulletin B-G-4 for General Specifications and to Test Method Bulletin)

Deflection at Break, minimum

Across grain (inch)	0.25
Parallel (inch)	0.15

Punch Test (lbs) 700 - 1100

Twist Test, maximum split

Face (inch)	3/4
Back (inch)	3/4

Hammer Loss Test, decigrams

Individual Test, maximum 5.0

Bond at High Humidity, maximum peel

Face (inch)	1/2
Back (inch)	1/2

Water Immersion Test, 2 Hours

1 inch head of water at 70 F
Maximum weight gain (ASTM C 473) 5%

Surface Water Absorption Test, Face & Back

Cobb Test, 70 F water for 2
Hrs (ASTM C 630)
Maximum weight gain 2 grams

NOTE: DO NOT use U.L. Bundling Tape on SOFFIT BOARD.

Bundle two pieces face to face with Soffit Board Bundling Tape. Ship board using same loading methods, unit sizes and weather protection as 5/8" NULL-A-FIRE board.